



Dart Aerospace Ltd.
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Tel (613) 632-5200

D350-591-311
Job Sheet 171664



Split a

Part No: D350-591-311

Job Qty: 10 ea

Part Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/7/18

Job Tracking No:

Due Date: 2/16/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3272-1 JLM IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		2/14/18	0.00	0.00	Start Up Large Fab-4		<i>SL</i>
110	Large Fab	10 pcs		2/15/18	0.00	9.91	Large Fab 2		<i>SL</i>
120	QC	10 pcs		2/15/18	0.00	0.00	QC9		<i>PD 18-02-20</i>
130	QC	10 pcs		2/15/18	0.00	0.00	QC5		<i>PD 16-02-20.</i>
140	HandFinish	10 pcs		2/15/18	0.00	1.84	HandFinish1		<i>HL 18-2-21</i>
150	QC	10 pcs		2/15/18	0.00	0.00	QC7-2		<i>PD 18-02-22</i>
180	Large Fab	10 pcs		2/15/18	0.00	9.91	Large Fab 2		<i>SL 18/02/27</i>
190	QC	10 pcs		2/15/18	0.00	0.00	QC10		<i>38</i>
200	QC	10 pcs		2/15/18	0.00	0.00	QC5		<i>38</i>
210	HandFinish	10 pcs		2/15/18	0.00	1.84	HandFinish1		<i>SL 18-02-28</i>
220	Powdercoat	10 pcs		2/15/18	0.00	2.90	Powdercoat1		<i>BR 18-3-1</i>
230	HandFinish	10 pcs		2/16/18	0.00	1.84	HandFinish3		<i>BR 18-03-01</i>
240	QC	10 pcs		2/16/18	0.00	0.00	QC3		<i>38</i>
250	Packaging	10 pcs		2/16/18	0.00	0.00	Packaging1-3		<i>9-88</i>
260	QC	10 pcs		2/16/18	0.00	0.00	QC4		<i>MAR 08-2018</i>
265	DC	10 pcs		2/16/18	0.00	0.00	DC		<i>17.10</i>
270	Packaging	10 pcs		2/16/18	0.00	0.00	Packaging3-1		<i>17.10</i>
280	QC21-FG	10 Ea		2/16/18	0.00	0.00	QC21		<i>MAR 12 2018</i>

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod *M138673* 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod *M138673* 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: *1:10* OVEN TEMPERATURE: *325°* FINISH TIME: *2:10*

265 - Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

270 - Identify and pack for shipping as per PPPD350-591-311 Location : FG084

wing walk M138761

FG084

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	10 Ea (1 ea)	90-Start up Operation	
D3219-1	Plate	20 Ea (2 ea)	90-Start up Operation	
D3272-1	Step	10 Ea (1 ea)	90-Start up Operation	
D3065-041	Step Leg Assembly	10 Ea (1 ea)	180-Large Fab	

001329

5042351x9x14

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

D3066-1	Spacer	20 Ea (2 ea)	180-Large Fab
D3067-1	End Plate	10 Ea (1 ea)	180-Large Fab
MS20600-AD4W4	Rivet	160 Ea (16 ea)	180-Large Fab
AN3-35A	Bolt	20 Ea (2 ea)	250-Packaging
AN4-13A	Bolt	80 Ea (8 ea)	250-Packaging
AN5-36A	Bolt	20 Ea (2 ea)	250-Packaging
D2230-3	Mounting Lug	40 Ea (4 ea)	250-Packaging
D2618	Bushing	20 Ea (2 ea)	250-Packaging
D2856-400-720	Abrasion Strip 4" X 7.20"	20 Ea (2 ea)	250-Packaging
D3235-1	Mounting Lug	20 Ea (2 ea)	250-Packaging
D3278-041	Support Assembly	10 Ea (1 ea)	250-Packaging
MS21042L3	Nut	20 Ea (2 ea)	250-Packaging
MS21042L4	Nut	80 Ea (8 ea)	250-Packaging
MS21042L5	Nut	20 Ea (2 ea)	250-Packaging
NAS1149D0363J	Washer	40 Ea (4 ea)	250-Packaging
NAS1149D0463J	Washer	160 Ea (16 ea)	250-Packaging
NAS1149D0563J	Washer	40 Ea (4 ea)	250-Packaging

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	10	91	0
	D3219-1	20	98	0
	D3272-1	10	10	0
180-Large Fab	D3065-041	10	2	0
	D3066-1	20	90	0
	D3067-1	10	91	0
250-Packaging	MS20600-AD4W4	160	1,321	0
	AN3-35A	20	164	0
	AN4-13A	80	618	0
	AN5-36A	20	90	0
	D2230-3	40	133	0
	D2618	20	36	0
	D2856-400-720	20	145	0
	D3235-1	20	6	0
	D3278-041	10	21	0
	MS21042L3	20	3,805	0
	MS21042L4	80	1,991	0
	MS21042L5	20	501	0
	NAS1149D0363J	40	3,717	0
	NAS1149D0463J	160	3,420	0
	NAS1149D0563J	40	1,501	0

Part Specifications

Specifications could not be found.

QA:

Date:

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐Scrap ☐Use-as-is ☐Suspected Unapproved ☐Skid-tube ☐Machining ☐Thermoforming ☐Large Fab ☐Cross tube ☐Small Fab ☐Finishing ☐Composite ☐Water Jet ☐Prod. Eng. Coord. ☐Rec/Store/Packaging ☐Supplier ☐Engineering ☐Quality ☐Other ☐

ate :

Step #:

QTY Effective :

MRB (QSI042) Approval

Description Work Order Deviation

Disposition

Completed By

Lead hand / Supervisor
Approval VerificationQC / QA Coordinator
Approval

FAULT CATEGORY

☐ Power Loss/Surge☐ Folio/Program☐ Grain☐ Weld☐ Wrong Stock Pulled☐ Out of Sequence☐ Off-set☐ Misabeled☐ Fit/Function☐ Misaligned/off center☐ Positioned Wrong☐ Outside Dimensions☐ Over/Under tolerance☐ Part Incorrect☐ Part Lost/Missing☐ Part Moved☐ Drawing☐ Finish☐ Misread☐ Turning Sequence

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CANADA
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Email: sales@dartaero.com
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Container No: S042351

Part: D350-591-311

Serial No/Batch: S042351

Revision: D3272

Inspector:

Date: 02/14/16 13:03 PM



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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
001389	S047799	AN3-35A	Bolt	s017089	ST348	18
001389	S047798	AN4-13A	Bolt	s027722	ST344	72
001389	S047797	AN5-36A	Bolt	s014157	ST336	18
001389	S047832	D2618	Bushing	s043411	ST008	18
001389	S009400	D2856-400-720	Abrasion Strip 4" X 7.20"	S009399	ST418	5
001389	S047828	D2856-400-720	Abrasion Strip 4" X 7.20"	s037326	ST418	13
001389	S038171	D3235-1	Mounting Lug	S038170	ST522	3
001389	S043414	D3235-1	Mounting Lug	S043413	ST522	2
001389	S049436	D3235-1	Mounting Lug	s049171	ST522	13
001389	S036128	D3278-041	Support Assembly	S036748	ST522	6
001389	S038697	D3278-041	Support Assembly	S036128	ST522	1
001389	S049424	D3278-041	Support Assembly	s048828	ST522	2
001389	S047775	MS21042L3	Nut	S038764	ST303	18
001389	S047774	MS21042L4	Nut	S045901	ST303	72
001389	S047773	MS21042L5	Nut	S016880	ST303	18
001389	S047741	NAS1149D0363J	Washer	S015269	ST263	36
001389	S047740	NAS1149D0463J	Washer	S027736	ST263	144
001389	S047734	NAS1149D0563J	Washer	S025743	ST263	36

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

02230-3 36x 5038157

Plex 3/8/18 3:07 PM dart.quirion.sonia

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	Hel-Access-Step™, Short Step – High Skid, LH
	X					D350-591-214	Hel-Access-Step™, Short Step – High Skid, RH
		X				D350-591-215	Hel-Access-Step™, Short Step – Low Skid, LH
			X			D350-591-216	Hel-Access-Step™, Short Step – Low Skid, RH
				X		D350-591-311	Hel-Access-Step™, Long Step – High Skid, LH
					X	D350-591-312	Hel-Access-Step™, Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.

Change Record

PAGE 1 OF 1

Part Number: D350-591-311/-312 (EURO P/N: 704A 1 6 012/-011)

Description: HELI-ACCESS STEP, HIGH SKID, LONG STEP LH/RH

[illegible]